

Date: Thursday, 23/04/2009 3:30:07 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPAD
Job Number : 47432	
Estimate Number : 12785	
P.O. Number :	Part Number : D356411 GY
This Issue : 23/04/2009 S.O. No. :	Drawing Number : D3564 REVD
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : D
Previous Run : 47012	Material :
Written By :	Due Date : 01/05/2009 Qty: 12 Um: Each
Checked & Approved By : <u>JW 09.04.24</u>	
Comment : : Est Rev:A New Issue 07-03-08 ec : Est Rev:B As per Rev C 07-07-09 JLM : Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC : Est Rev:D Comments revised on Step 5, 6 per B44656 09-02-06 KJ Verified By:	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 Sheet .063
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Comment: Qty.: 1.4805 sf(s)/Unit Total: 17.7660 sf(s)
 M304S16GA Stainless steel sheet 0.063" thick
 Batch: 111323 B 9-5-19

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3564 ***** (D3564-1F) *****
 Dwg Rev: D
 Prog Rev: D B 9-5-19
 2-Deburr if necessary B 9-5-19

(12)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

505/65/19 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 23/04/2009 3:30:07 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 47432

Part Number: D356411

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3564 using Jigs DT8179

SB 09/05/19

(12)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/05/19

(X12)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty

Description

Batch

A/R

2059B Hardcoat

M111585

Weld hardcoat as per Dwg D3437

EL 9-5-20

(X12)

8.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 09/05/20

(X12)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/05/20

(X12)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

8:20

OVEN TEMPERATURE:

300°

FINISH TIME:

8:50

ump 09/05/21

(X12)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-05-21

(X12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 23/04/2009 3:30:07 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 47432

Part Number: D356411

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP 19

UMD

09/05/21

(X12)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/24 JA

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 09.05.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 47432
Description: Wearshoe		Part Number: D3564-11
Inspection Dwg: D3564	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.226	*			
2.432	+/-0.010	2.438	X			
2.50	+/-0.030	2.50	*			
6.000	+/-0.010	6.004	X			
12.104	+/-0.010	12.107	X			
18.000	+/-0.010	18.000	*			
18.00	+/-0.030	18.00	X			
9.00	+/-0.030	9.00	X			
11.50	+/-0.030	11.50	X			
0.300 x 0.300	+/-0.010	302 x 304	X			
Ø0.188	+0.005/-0.001	.189	X			
R0.375	+/-0.010	.375	X			
0.063	+/-0.010	.060	X			

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 9-5-19	Date: 09/05/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	
B	07.11.23	Dwg Rev updated	KJ/EC/DD	



RELEASED

07.09.04 *ff*



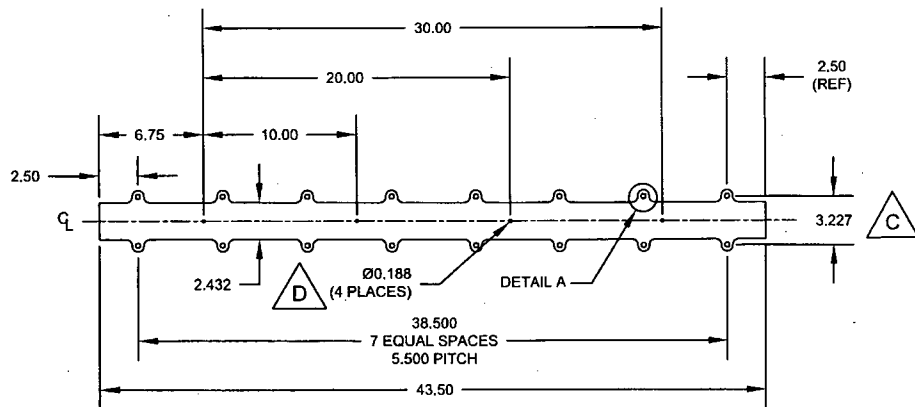
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NO. 17135

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)

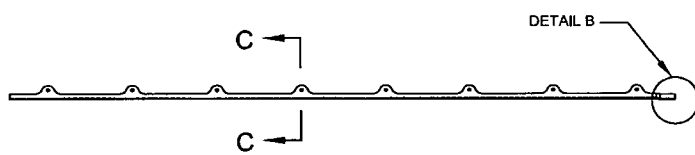
- WEIGHTS:**
- | | |
|----------|----------|
| D3564-1 | 1.85 lbs |
| D3564-3 | 1.85 lbs |
| D3564-5 | 1.93 lbs |
| D3564-7 | 1.26 lbs |
| D3564-9 | 1.85 lbs |
| D3564-11 | 1.85 lbs |
| D3564-13 | 0.38 lbs |
| D3564-15 | 0.80 lbs |

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5, C5: ADD D3564-15; PG1 B6, B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ON PG1; PG3 B8, C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5, 7, B2: RELOCATE DETAILS AND SECTION; PG3 A5, 7, B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. D D3564 SHEET 1 OF 3 TITLE SCALE WEARSHOE 1:	
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	21		
APPROVED	21		
DE APPR.	21		
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

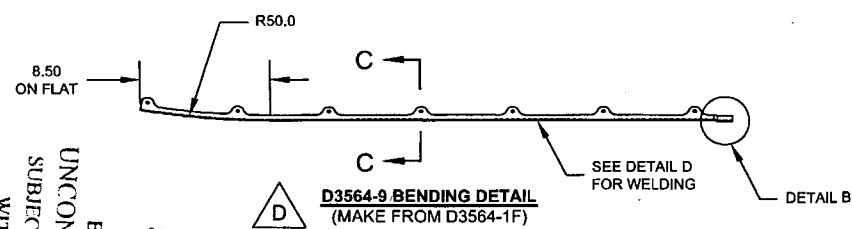
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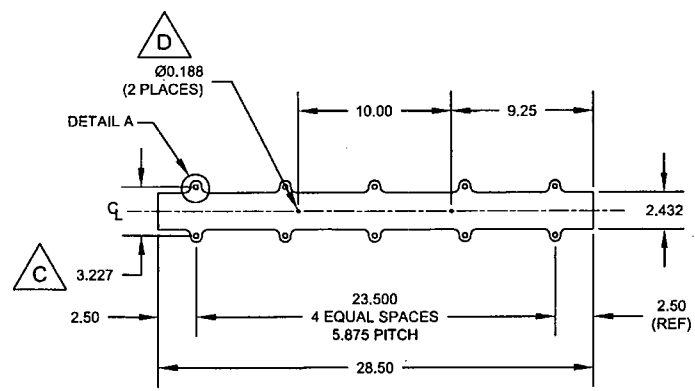
D3564-5F FLAT PATTERN



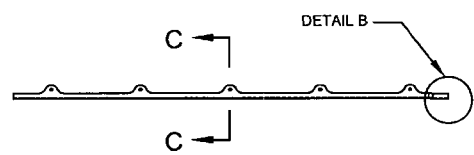
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



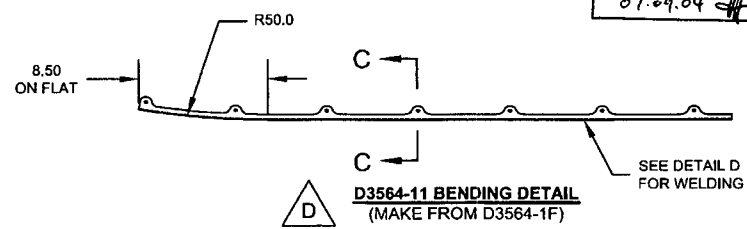
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

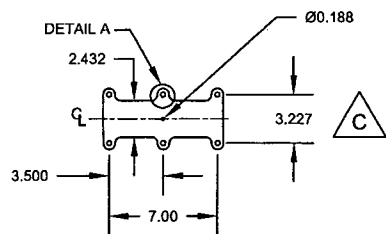
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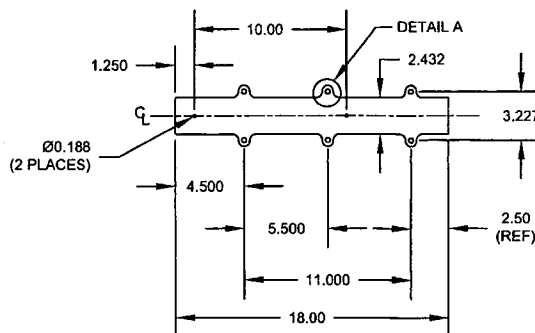
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CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
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DE APPR.	PH	WEARSHOE	1:8
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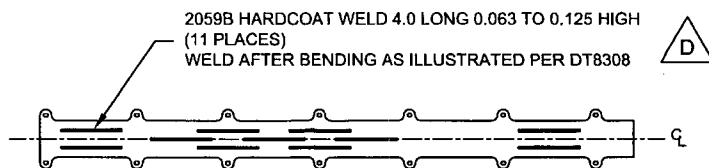
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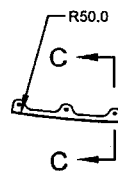
D3564-13F FLAT PATTERN



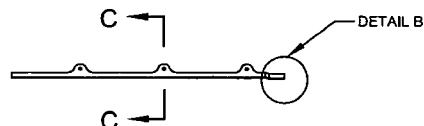
D3564-15F FLAT PATTERN



DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



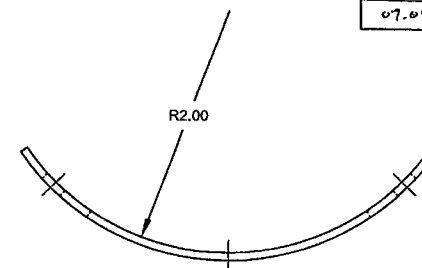
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



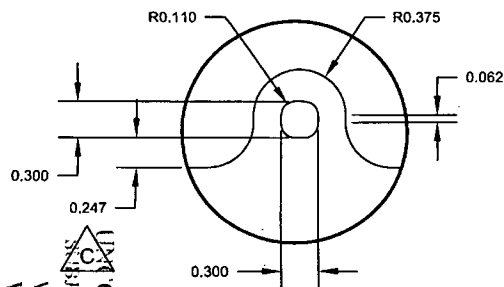
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)

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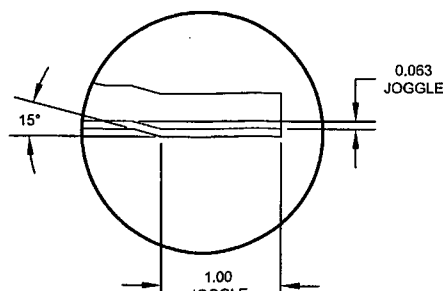
07.09.04



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

DESIGN	PH	DART AEROSPACE LTD	
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CHECKED	PH	DRAWING NO.	REV. D
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